

Work Order ID 119015

July-10-14 10:28:53 AM

119015

Page 1

Item ID: D3886-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Lug Assembly

Start Date: 4/30/14 Start Qty: 14.00 *14* Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 14.00 *14* Customer:

Reference:

Approvals: Process Plan: MUS Date: 140507 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3886	B								

100 0.00

100

Waterjet

FLOW CNC Waterjet

Memo

FLOW WATER JET

1-Cut as per Dwg D3886-3

Dwg Rev: 3

Prog Rev: 3

2-Deburr if necessary

18 mm 14/07/17

110 0.00

QC2- Inspect parts off machine FAI/FAIB

110

QC

Quality Control

Memo

18 mm 14/07/17

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Stop ***NR2***

DAS
38
9-89

14-8-26

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Item ID: D3886-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Lug Assembly

Stop *NS2*

Start Date: 4/30/14 **Start Qty:** 14.00

14

Cust Item ID:

Required Date: 5/05/14 **Req'd Qty:** 14.00

14

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

0.00

Large Fab

Memo

Weld as per Dwg D3886 and QSI 004 use DT9626

A/R SS ROD Batch: M126048

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

0.00

QC

Memo

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

0.00

QC

Memo

Quality Control

Work Order ID 119015

119015

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Item ID: D3886-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug Assembly
Start Date: 4/30/14 Start Qty: 14.00 ***14*** Cust Item ID:
Required Date: 5/05/14 Req'd Qty: 14.00 ***14*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M 126959.</i> Memo	0.00 <i>3:10</i> <i>403</i> <i>340.</i>				<i>18</i>	<i>14-9-11</i>	<i>838</i>	
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>18</i>	<i>14/09/12.</i>		
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <i>51529</i> Memo	0.00 0.00				<i>18</i>	<i>14-9-16</i>		

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Lug Assembly

Stop *NS2*

Start Date: 4/30/14 **Start Qty:** 14.00

14

Cust Item ID:

Required Date: 5/05/14 **Req'd Qty:** 14.00

14

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #	Plan Code
--------	-----------

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12-14-9-16

Picklist Print

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Page 1

Work Order ID: 119015

119015

Parent Item: D3886-041

D3886-041

Parent Item Name: Lug Assembly

Start Date: 4/30/14

Required Date: 5/05/14

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S12GA

Purchased

No

100

sf

109.6300

0.1472

3

M304S12GA

304/316 0.100" Sheet

**

3.0

mm 17/07/12

Location

Loc Qty

Loc Code

MAT019

109.63

113062

76.13

113077

19

m126309

14.5

3.0

D3886-1

Manufactured

No

150

Each

34.0000

1

14

D3886-1

Lug

**

149-9

Location

Loc Qty

Loc Code

WA001

34

103005

14

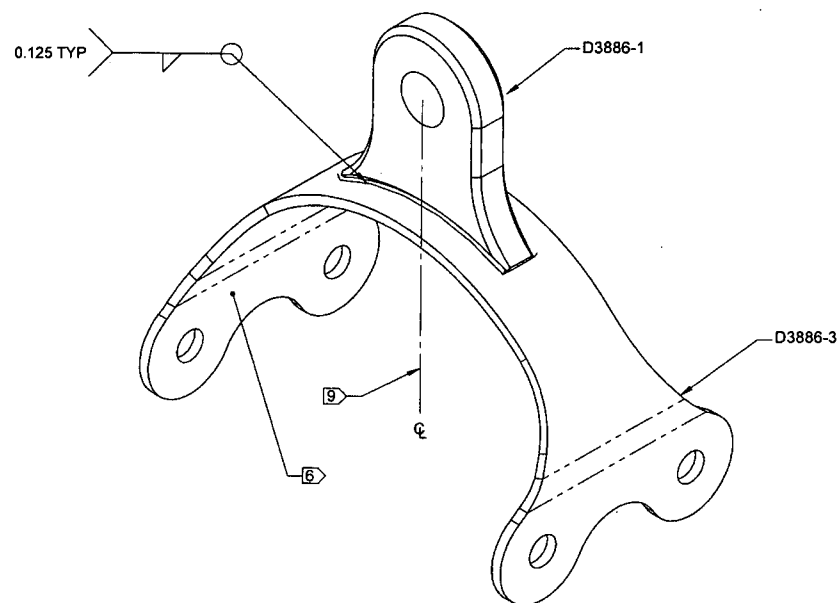
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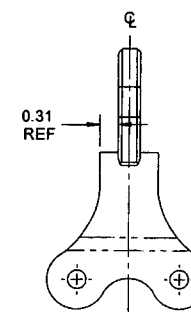
16

123074 X +

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



D3886-041 LUG ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119015

ML5
1405-07

RELEASED
06/15/11

NOTES:

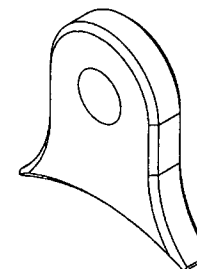
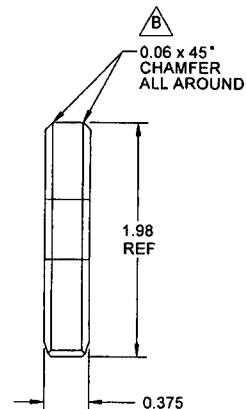
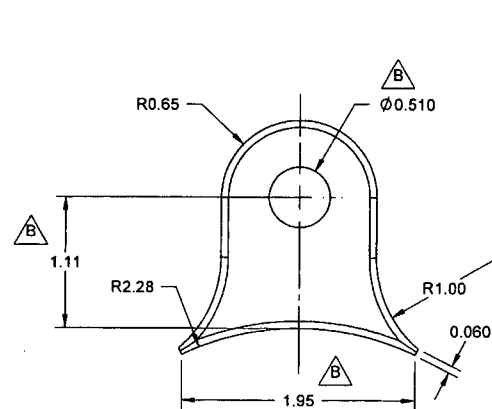
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
- 7) WEIGHT: 0.53 lbs
- 8) WELD PER DART QSI 004
- 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE C

B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.30		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3886** REV. B
SHEET 1 OF 4
TITLE **LUG ASSEMBLY** SCALE NTS

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D3886-1 LUG B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

RELEASED
09/07/12

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DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D3886	SHEET 2 OF 4
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	LUG ASSEMBLY	NTS
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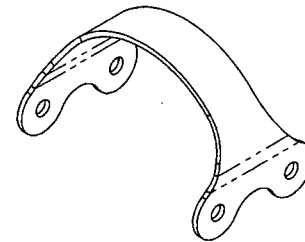
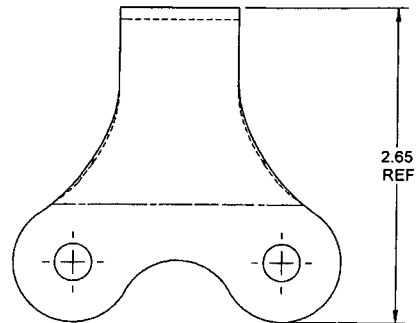
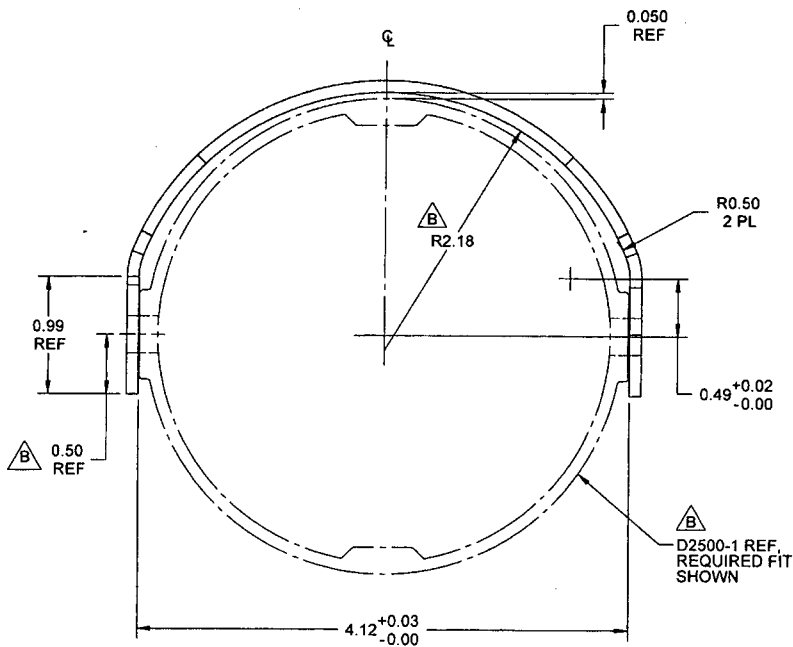
8 7 6 5 4 3 2 1

D

C

B

A



D

C

B

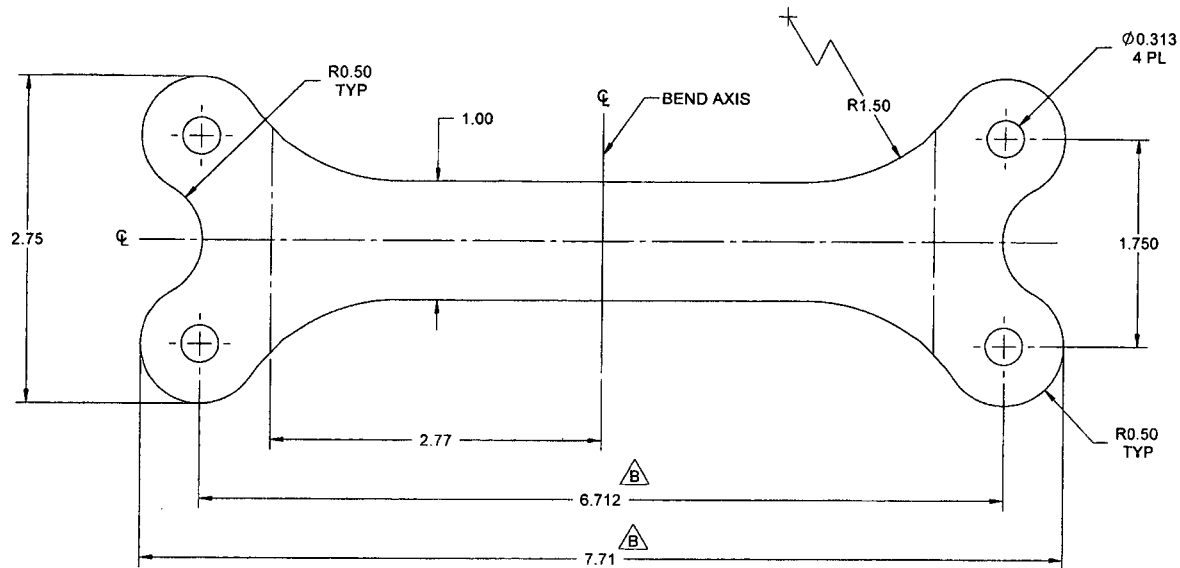
A

D3886-3 BRACKET
(MAKE FROM D3886-3F)

RELEASED
9/6/15/10

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8 7 6 5 4 3 2 1



D3886-3F FLAT PATTERN $\triangle B$

RELEASED
9/6/15

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 12 GAUGE (0.100) THICK, (REF. DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

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DRAWN	RF	PORT HADLOCK, WA	
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MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
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